

Tuesday, 09/12/2008 9:38:56 AM

Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 43951
Estimate Number : 13592
P.O. Number :
This Issue : 09/12/2008 **S.O. No.** :
Prsht Rev. : NC
First Issue : / / **Type** : R&D THERMOFORMING
Previous Run : 42074
Written By :
Checked & Approved By : JUD 08.12.09
Comment : Est. A New Issue 08/09/17 DL

Drawing Name : HAT BIN 206 A/B
Part Number : D38241
Drawing Number : D38241 PROTOTYPE
Project Number : IN0002
Drawing Revision : PROTOTYPE
Material : MKYD6185S080P362015
Due Date : 16/12/2008 **Qty:** 1 **Um:** Each

— PROTOTYPE
Plt 08.12.22

Additional Product

PROTOTYPE

Job Number:



UPDATED Plt 08.12.22

Seq. #:	Machine Or Operation:	Description :	
1.0	MKYD6185S080P362015	6185 KYDEX .080"	
Comment: Qty.: 11.3747 sf(s)/Unit Total: 11.3747 sf(s) 6185 Kydex .080"		MATERIAL CERTIFICATION REQ'D UPON DELIVERY	
		4109703 BB 08/12/15	
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
	1) Machine set up	BB 08/28/11	(X 2)
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
	1) Cut sheet to required blank size	BB 08/28/11	(X 2)
4.0	THERMOFORMING	THERMOFORMING MACHINE	
Comment: THERMOFORMING MACHINE			
Thermoform as per Dwg. D3824-1 and folio (FTA 9405 Prototype) using tool DT 9405			
	Dwg. Rev. <u>A</u>		
	Folio Rev. <u>B</u>	BB 08/28/11	(X 2)
5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			
	Visually inspect for proper formation of each part	BB 08/28/11	(X 2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/12/15	6.	Scrap. While applying a reinforcement doubler on the back side of the part, the glue reacted with the material. Le Page contact cement was used, and the Kydex was <u>very</u> thin in the deepest corners.	<i>[Signature]</i>	Scrap & destroy. Qty 1 Bonding agent is yet to be determined.	<i>[Signature]</i> 08.12.15	→	<i>[Signature]</i>	<i>[Signature]</i> 08-12-15
		P.C: un-approved adhesive, and not compatible with the material. prototype	<i>[Signature]</i>				<i>[Signature]</i>	<i>[Signature]</i> 08-12-15

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HAT BIN 206 A/B

Job Number: 43951

Part Number: D38241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/12/12 (1)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

08/01/12

X 1 BB

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

08/01/12

X 1 BB

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.12 AS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

NOT FOR STOCK # 08.12.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08.12.16

Prototype

Job Completion



W 08.12.24 with deviation per
for attached

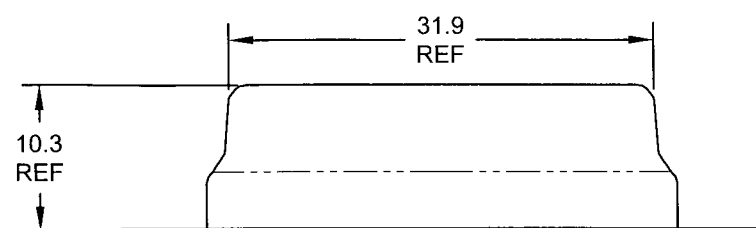
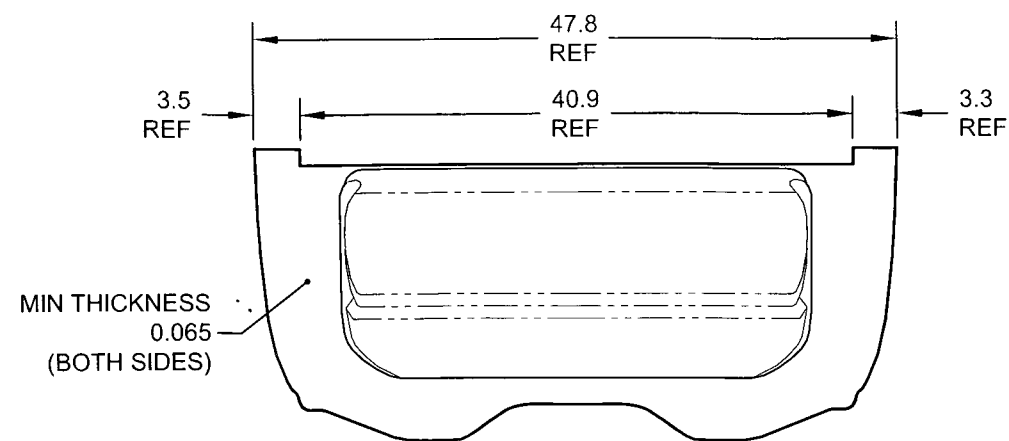
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

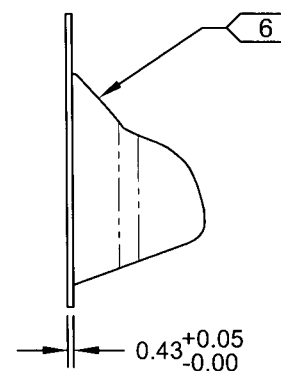
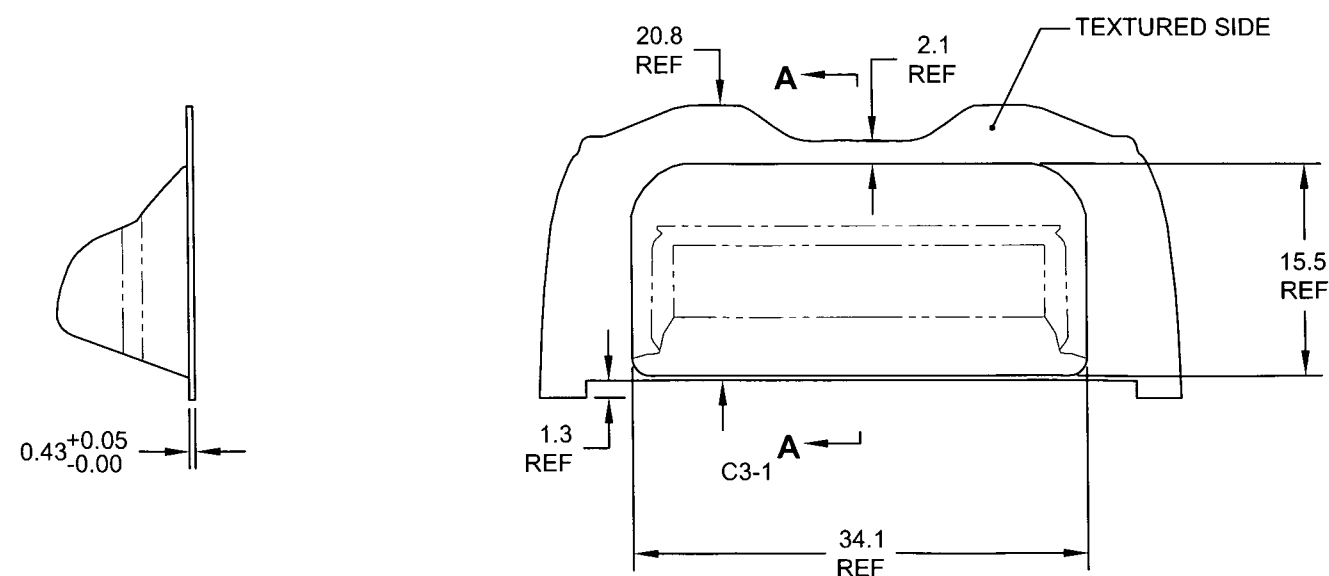
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A
SCALE 2X



D3824-1 HAT BIN

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.1 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.03 RA

A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3824	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		HAT BIN	NTS
DATE	08.10.01	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	


DART AEROSPACE LTD	Work Order: 43951
Description: Hat Bin 206 A/B / Prototype	Part Number: D3824-1
Inspection Dwg: D3824 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype




THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: 	Date: 08.12.12
---	-----------------------

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.065	Min	0.063	✓	✓		The lowest I found.
10.3 (Ref)	± 0.100	10.25	✓			
31.9 (Ref)	± 0.100	31.9125	✓			
34.1 (Ref)	± 0.100	34	✓			
2.1 (Ref)	± 0.100	2.125	✓			
20.8 (Ref)	± 0.100	20.8	✓			
1.3 (Ref)	± 0.100	1.25	✓			
40.9 (Ref)	± 0.100	40.9375	✓			
47.8 (Ref)	± 0.100	47.8125	✓			
0.43	$+0.05/-0.0$	0.46	✓			

Measured by: 	Date: 08.12.12
Audited by: 	Date: 08.12.12
Prototype Approval: 	Date: 08.12.12

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

Receiving Report

Date: 8/10/24

Batch No: M109703

Supplier: SABIC

Dart P/O: 7280

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
 Waybill Attached: Yes ☒ No ☐ N/A ☐
 Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection as per 27 N/A ☒
 Work Order _____

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Admin: _____

Location _____

سابك
sabic

SABIC Polymershapes

250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 10/3/2008

YOUR PURCHASE ORDER : 7280

OUR SHIPPER NO: 084287

LINE ITEM # : 1

QUANTITY: 51

59 8 Oct 27

08/10/27

DESCRIPTION: .080 x 48 x 96 Kydex 6185-P3 IVORY 62015.

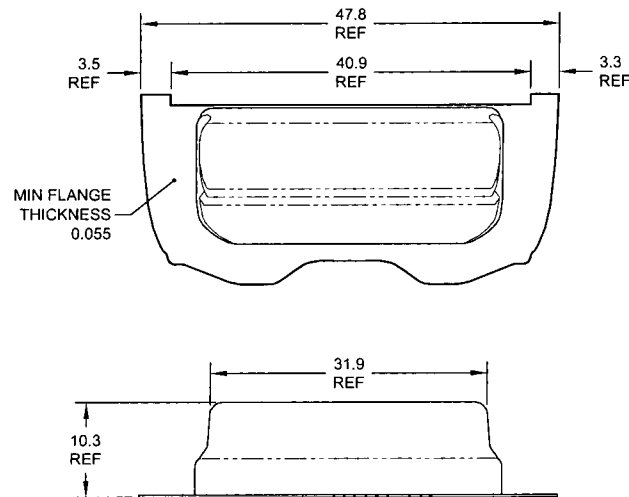
THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25.853 (a)

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

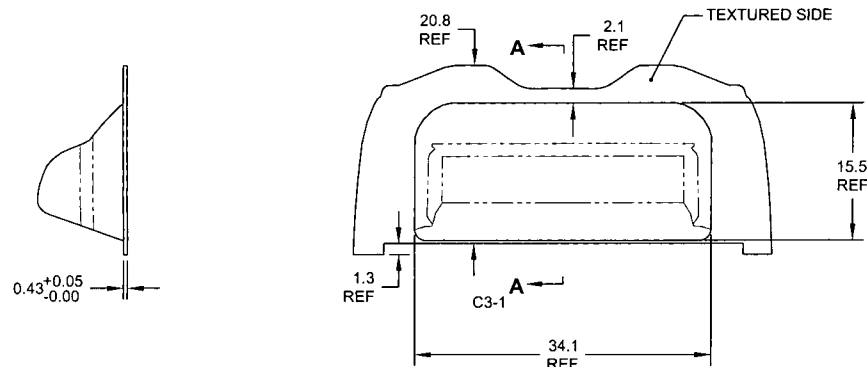
AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER



SECTION A-A
SCALE 2X



D3824-1 HAT BIN
(BELL 206 A/B)

NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
(REF DART SPEC MKYD6185S.080-P3-62015)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3824-1" USING VIBRATING STYLUS
- 7) WEIGHT: 3.7 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.12.22 *PH*
NOT REVISED FROM
08.12.08 *PH* DWG TO
INCLUDE DIMENSION
UPDATE PER FAT SHEET
PJ

REV.	NEW ISSUE	DESCRIPTION	PH	08.10.01
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.10.01			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3824
HAT BIN (BELL 206 A/B)
REV. A
SHEET 1 OF 2
SCALE
NTS

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